

Work Order ID 76282

76282

Page 1

Tuesday, November 08, 2011 1:31:22 PM

Item ID: D3908-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Lug Assembly, Aft

Start Date: 11/8/2011 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/22/2011 Req'd Qty: 2.00

2

Customer:

Reference:

Run Start ***NR1***

Approvals:

Process Plan: M.L.J

Date: 11/11/08 Tooling:

Date:

Stop ***NR2***

QC:

Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3908	C

100 Pick Kit 0.00

100

Packaging Memo 0.00

Packaging

EB 11/11/28 (2)

110 0.00

110

Small Fab Memo 0.00

Small Fab 1- Assemble as per dwg
TRIM RIVETS 1.185" LONG

EB 11/11/28 (2)

120 QC5- Inspect part completeness to step on W/O 0.00

120

QC Memo 0.00

Quality Control

W 11.11.28 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76282***76282***

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Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

130

Identify as per dwg & Stock Location: ST 471 0.00***130***

Packaging

Memo

0.00

Packaging

SP 11-11-28

140

QC21- Final Inspection - Work Order Release 0.00

140

QC

Memo

0.00

Quality Control

11/11/29
UMK
11-11-28

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Picklist Print

Tuesday, November 08, 2011 1:31:26 PM

Page 1

Work Order ID: 76282

76282

Parent Item: D3908-041

D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 11/8/2011

Required Date: 11/22/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC
As per Rev B 10-04-06 VERIFIED BY:DD
10.05.27 DD verf:EC
10.05.28 DD verf:EC
IPP REVB:
IPP Rev:C as per PC1
IPP Rev:D per ECN10-581

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2690-6 *D2690-6* Lanyard Assembly		Manufactured	No			100	Each	28.0000	1	2			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST020				28					
				73324				8					
				74515				20					
D3908-1 *D3908-1* Lug Plate, Aft Crosstube		Manufactured	No			100	Each	5.0000	2	4			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST090				5					
				73539				5					
D3908-3 *D3908-3* Stud Receiver, Lower		Manufactured	No			100	Each	1.0000	1	2			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST090				1					
				68260				1					

B76283
(1X)

W/O:		WORK ORDER CHANGES					
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Parent Item: D3908-041

D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 11/8/2011

Required Date: 11/22/2011

Start Qty: 2.00

Required Qty: 2.00

D3908-5 Manufactured No

100 Each 3.0000 1 2

D3908-5

Eyebolt Stud

**

EP 11/11/28

Location Loc Qty Loc Code

GA 1

57428 1

ST090 2

59670 2

D3910-1 Manufactured No

100 Each 28.0000 1 2

D3910-1

Crosstube Lug

**

EP 11/11/28

Location Loc Qty Loc Code

ENG 2

70160 2

st507 26

73527 26

D4091-1 Manufactured No

100 Each 10.0000 1 2

D4091-1

Mounting Lug

**

EP 11/11/28

Location Loc Qty Loc Code

ST460 10

69605 10

2

W/O:		WORK ORDER CHANGES					
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Parent Item: D3908-041

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Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 11/8/2011

Required Date: 11/22/2011

Start Qty: 2.00

Required Qty: 2.00

AN3C12A Purchased No

100 Each 108.0000 2 4

AN3C12A

Bolts

**

EP 11/11/28

Location

Loc Qty

Loc Code

ST351

108

117514

4

118112

5

118422

17

118451

22

118838

10

119510

50

4

AN4C13A Purchased No

100 Each 49.0000 1 2

AN4C13A

BOLT

**

EP 11/11/28

Location

Loc Qty

Loc Code

ST357

49

118838

49

2

MS17984-C413 Purchased No

100 Each 11.0000 1 2

MS17984-C413

PIN, QUICK RELEASE

**

EP 11/11/28

Location

Loc Qty

Loc Code

ST315

11

114340

1

118612

2

119307

8

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Page 4

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Parent Item: D3908-041

D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 11/8/2011

Required Date: 11/22/2011

Start Qty: 2.00

Required Qty: 2.00

MS20615-4M20

Purchased

No

100

Each

114.0000

6

12

**

MS20615-4M20

RIVET

Location

Loc Qty

Loc Code

GA

114

117071

30

118571

34

119546

50

MS21043-3

Purchased

No

100

Each

727.0000

2

4

**

MS21043-3

Nut

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

655

118077

1

118614

477

118686

177

MS21043-4

Purchased

No

100

Each

1,557.000

1

2

**

MS21043-4

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1517

117793

22

118686

500

119309

495

119546

500

Tuesday, November 08, 2011 1:31:27 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Page 5

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D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 11/8/2011

Required Date: 11/22/2011

Start Qty: 2.00

Required Qty: 2.00

NAS1149C0332R

Purchased

No

100

Each

2,352.000

4

8

NAS1149C0332R

Washer

**

EPB 11/11/20

Location

Loc Qty

Loc Code

FP-B

7

117291

7

ST297

2345

116304

55

117460

18

117887

169

118078

2

118179

78

118354

1283

119124

740

8

NAS1149C0432R

Purchased

No

100

Each

4,412.000

2

4

NAS1149C0432R

Washer

**

EPB 11/11/20

Location

Loc Qty

Loc Code

ST297

4412

117291

3412

119124

1000

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

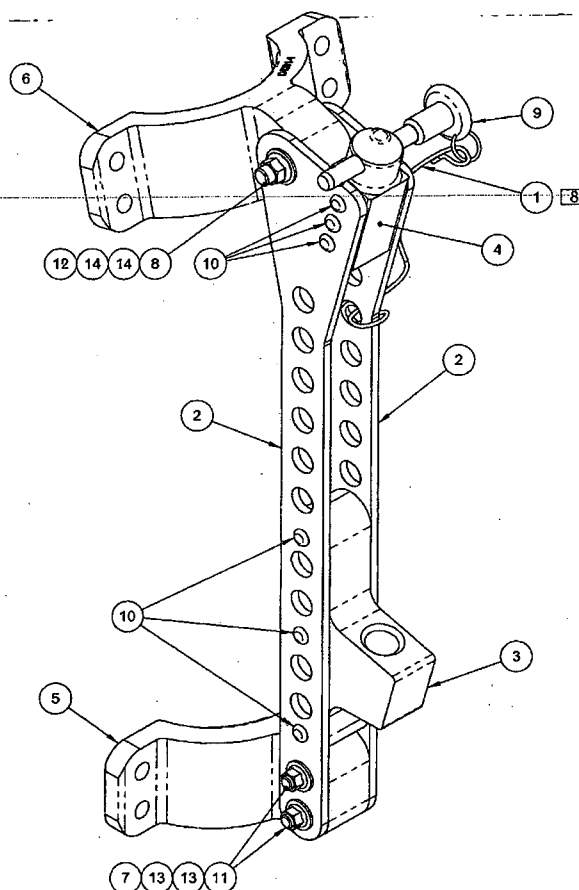
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NOTE: Date & initial all entries

ITEM	QTY.	P/N	DESCRIPTION
	X	D3908-041	X-TUBE LUG ASSY (AFT)
1	1	D2690-6	LANYARD
2	2	D3908-1	AFT X-TUBE LUG PLATE
3	1	D3908-3	STUD RECEIVER LOWER
4	1	D3908-5	EYEBOLT STUD
5	1	D3910-1	X-TUBE LUG
6	1	D4091-1	MOUNTING LUG
7	2	AN3C12A	BOLT
8	1	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	6	MS20815-4M20	RIVET
11	2	MS21043-3	NUT
12	1	MS21043-4	NUT
13	4	NAS1149C0332R	WASHER
14	2	NAS1149C0432R	WASHER



D3908-041 X-TUBE LUG ASSY (AFT)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 26282
11-11-08
RELEASED
2010-05-28
W

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3908-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.34 lbs
- 8) ATTACH TO D3908-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING.

C	REDESIGNED ITEM #2: ITEM#6 REPLACES QTY 1 ITEM#5: QTY 2 FOR ITEMS #7 & 11 WAS QTY 4, QTY 8 FOR ITEM #13 WAS 4, ADDED ITEMS #8, 12 & 14	MB	10.05.27
B	BOM: D3908-5 REPLACED WITH D3908-5, QTY 1 ADDED: D2690-6 & MS17984-C413. SHEET 5: ADDED D3908-5	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. C
CHECKED		D3908	SHEET 1 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		X-TUBE LUG ASSY (AFT)	NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.05.27		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

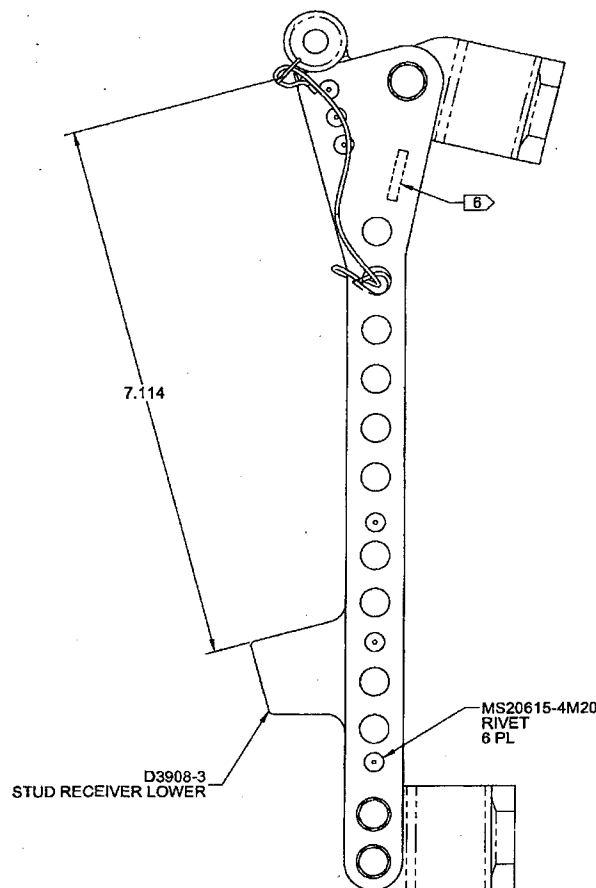
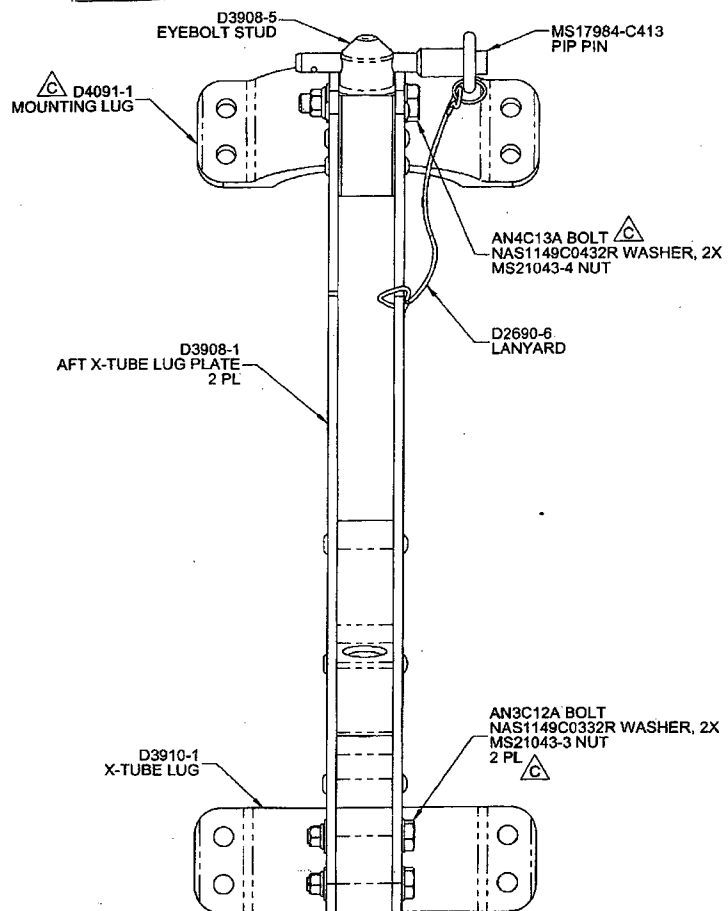
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



76282

RELEASED
2010-05-28
JND

D3908-041 X-TUBE LUG ASSY (AFT)

DESIGN	JFH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS
DATE	10.05.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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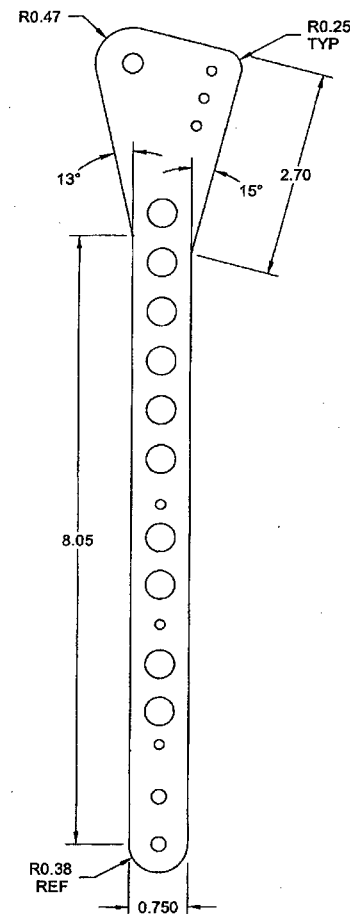
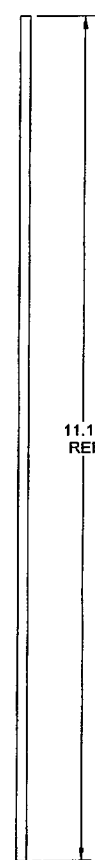
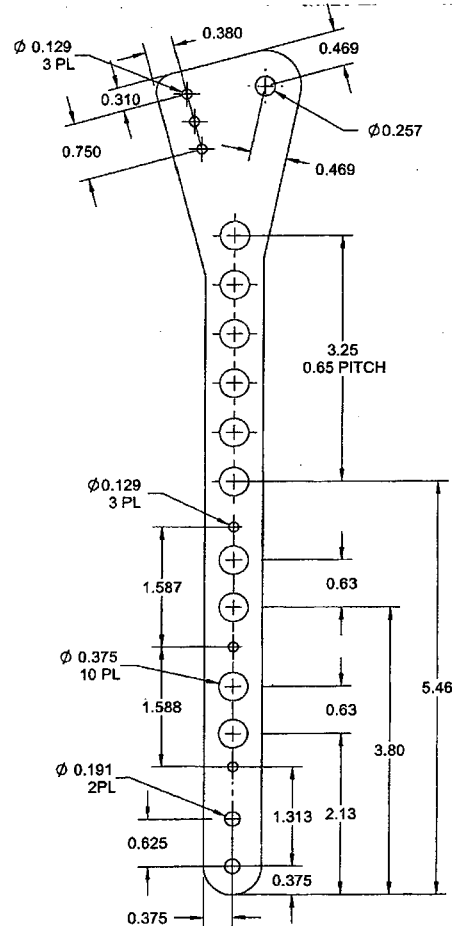
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NOTE: Date & initial all entries



76282

RELEASED
2010-05-28
MD

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5058 OR AMS 5613/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.31 lbs

D3908-1 AFT X-TUBE LUG PLATE

DESIGN	JRH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3908	REV. C
MFG. APPR.			SHEET 3 OF 5
APPROVED		TITLE X-TUBE LUG ASSY (AFT)	SCALE NTS
DE APPR.			
DATE	10.05.27		

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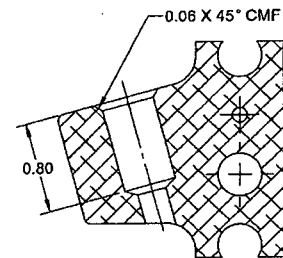
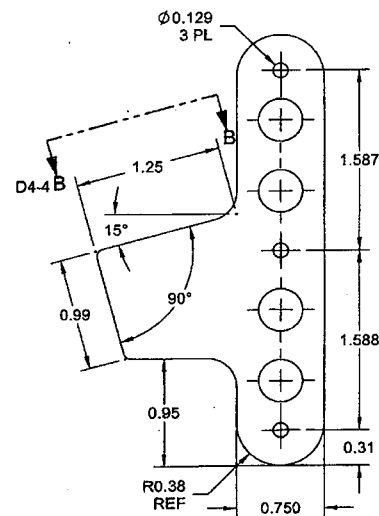
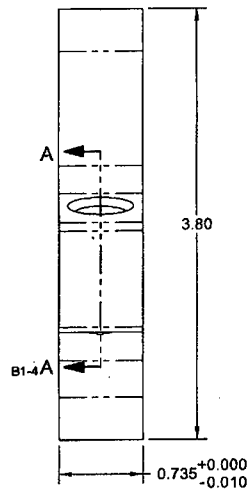
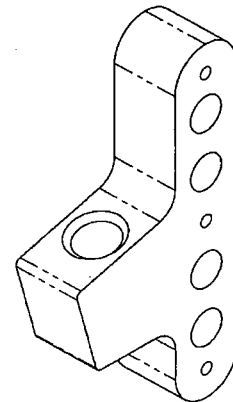
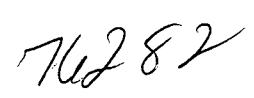
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NOTE: Date & initial all entries




SECTION A-A B6-4

D3908-3 STUD RECEIVER LOWER

RELEASED
2010-05-28

NOTES

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
PER PART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.69 lbs

DESIGN	JFH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS
DATE	10.05.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO PART OF IT OR THE EXPRESS OR IMPLIED CONTENT THEREOF IS TO BE USED FOR ANY PURPOSE OR TO BE COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

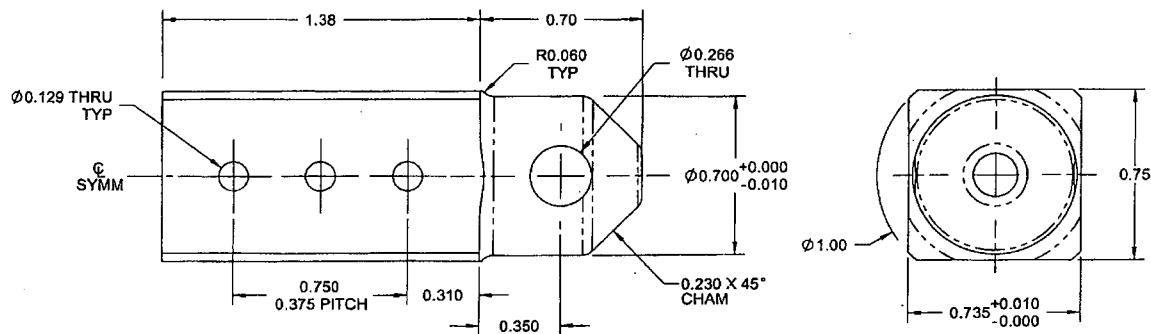
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NOTE: Date & initial all entries



D3908-5 EYEBOLT STUD

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

DESIGN	JFH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3908 REV. C SHEET 5 OF 5 TITLE X-TUBE LUG ASSY (AFT) SCALE NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	10.05.27	

RELEASED
2010-05-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries